

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011160**Date Inspected:** 29-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Ying Xin, Du Zhi Qun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10 SOUTH TOWER LIFT 4 CORNER B/C

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

SSTL4-1B/L-5A

SSTL4-1L/L-3A

BAY 11 EAST TOWER LIFT 4 CORNER A/B

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ESTL4-2B/L-59A/B (FROM 131M TOP TO 143M)

ESTL4-2L/L-4A/B

BAY 11 EAST TOWER LIFT 4 B/C CORNER TRIANGLE PLATE

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ESTL4-2H/L-87, 85

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

SOUTH TOWER LIFT 4 B/C CORNER TRIANGLE PLATE

FCAW welding of weld joint 119 located on SSTL4-1J/L.

Welder is identified as 053869. ZPMC CWI is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

TOWER INTERIOR SPLICE PLATE REPAIR

FCAW welding of weld joint 1A located on NSD1-SPSA4-18.

Welder is identified as 040261. ZPMC CWI is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR.

TOWER SPARE STRUT

SMAW welding of weld joint 33 located on ND1-STSA3-1-99M-1.

Welder is identified as 040582. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SMAW welding of weld joint 46 located on ND1-STSA3-1-99M-1.

Welder is identified as 040268. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-4113-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

for your project.

| | | |
|----------------------|---------------|-----------------------------|
| Inspected By: | Gaikwad,Umesh | Quality Assurance Inspector |
|----------------------|---------------|-----------------------------|

| | | |
|---------------------|------------------|-------------|
| Reviewed By: | Clifford,William | QA Reviewer |
|---------------------|------------------|-------------|